

Work Order ID 85761

85761

Page 1

Thursday, June 14, 2012 2:30:14 PM

Item ID: D3017-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Back Frame Assembly

Start Date: 6/14/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/25/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 12-06-14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3017	Rev B								

100 Weld per dwg A/R 4130 rod Batch: *M118875* 0.00

100

Large Fab

Memo

0.00

Large Fab

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

①

EZ 12-9-14

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control



12-09-17

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:15

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:45

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

ML 21279

LX 12/09/17 ML

LX 12/09/17

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Required Date: 6/25/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location

0.00

150

Packaging

Memo

0.00

Packaging

1X

12/09/18

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/9/19

12-09-18

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Thursday, June 14, 2012 2:30:14 PM

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083 4130 RD Tube .750 x .083W		Purchased	No			100	f	37.8970	2.458	2.5873684		12-9-14	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT033	37.897	
117579	13.98	
117973	23.917	

M4130NT0.750W.049	Purchased	No	100	f	105.9200	11.125	11.710526
4130 RD Tube .750 x.049W							12-8-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT033	105.92	
120350	65.61	
121025	40.31	

D3017-11	Manufactured	No	100	Each	50.0000	2	2	12-9-14
cap								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA021	50	
76851	50	

D3017-7	Manufactured	No	100	Each	6.0000	3	3
Lug							17 12-9-14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA021	6	
70905	6	

$$86091 \times 3$$

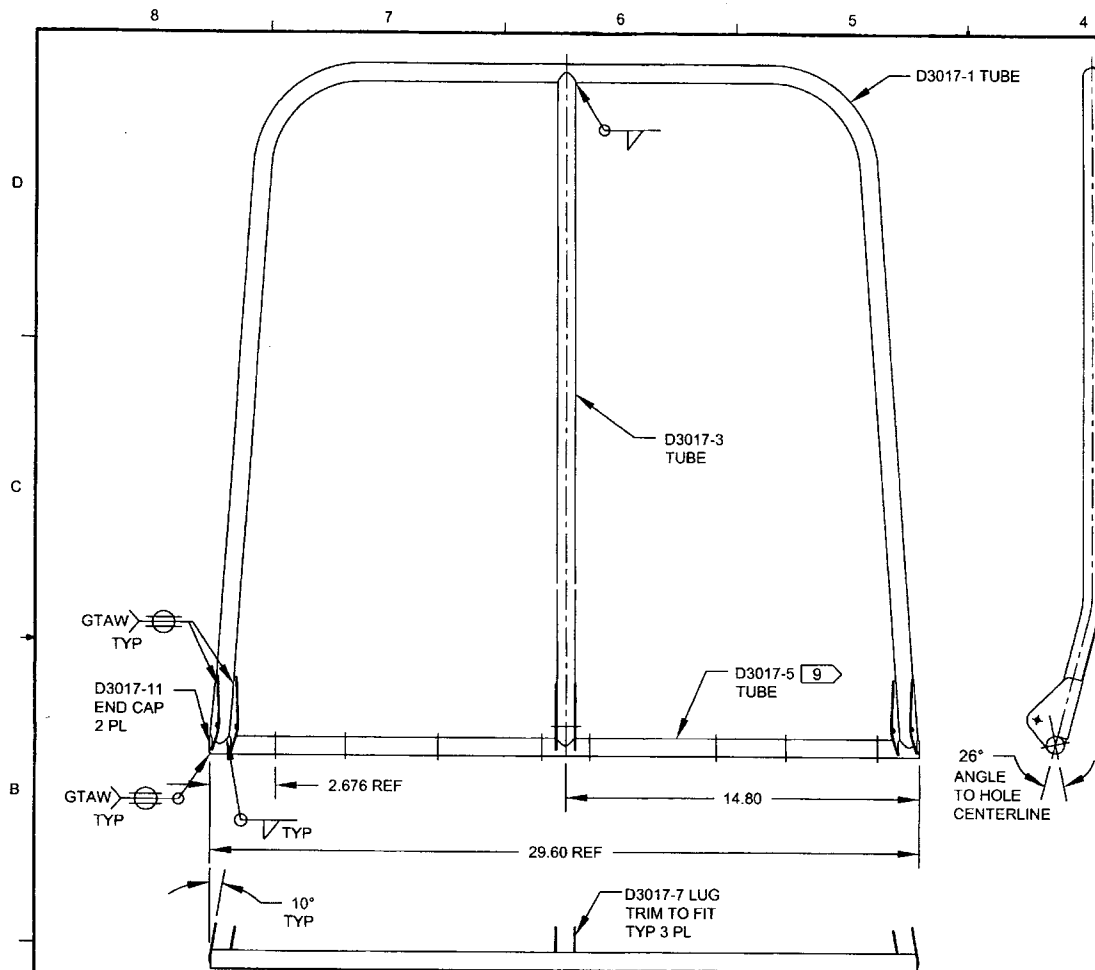
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ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

26°
ANGLE
TO HOLE
CENTERLINE

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

RELEASED
2010-02-02

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3017	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		BACK FRAME ASSEMBLY	NTS
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DATE	10.01.13		

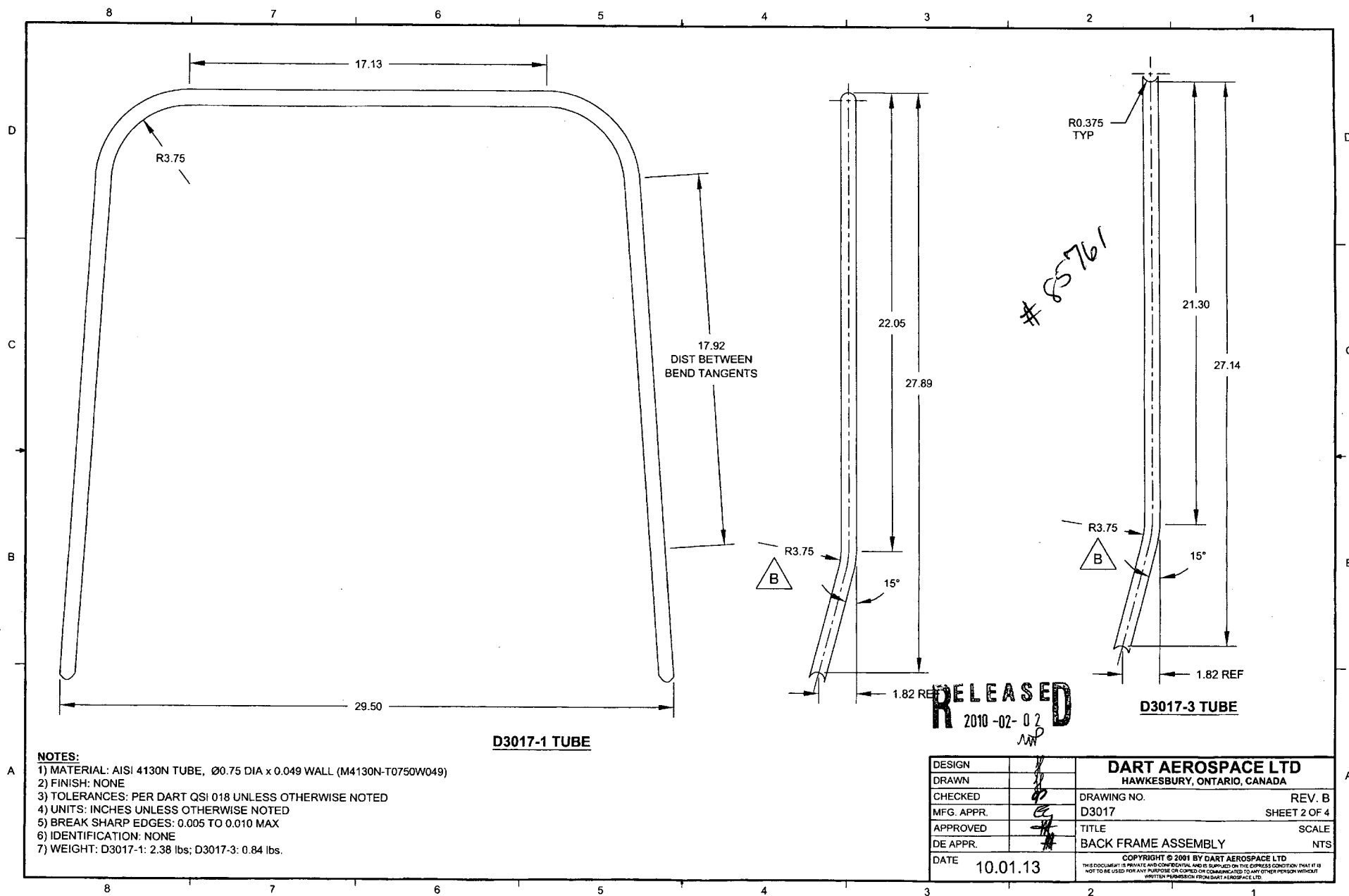
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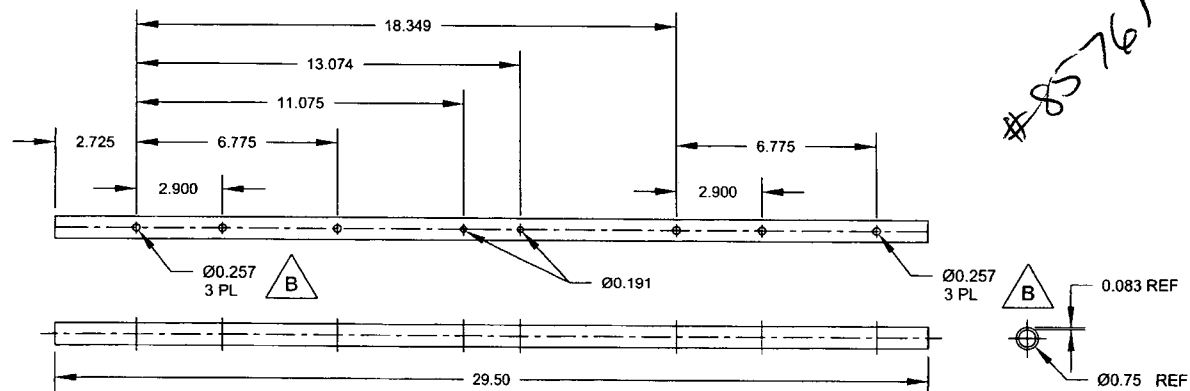
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D3017-5 TUBE

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, 0.75 DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
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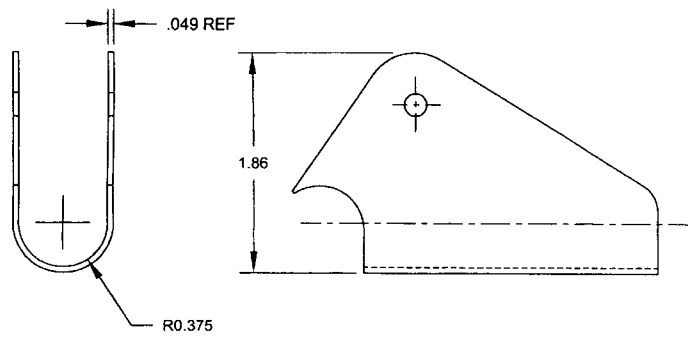
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D

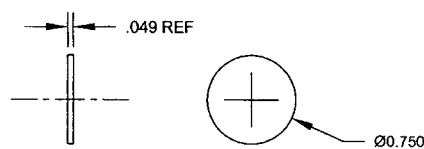
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B

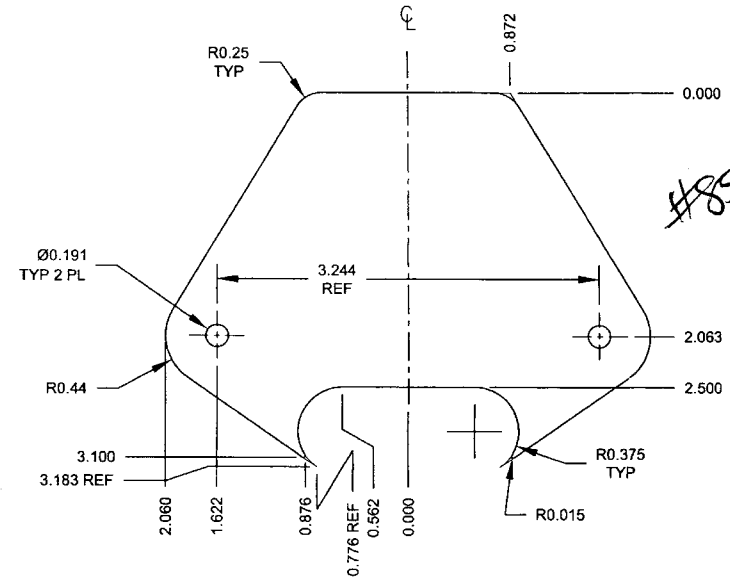
A



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

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8 7 6 5 4 3 2 1

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